



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2857-2
Job Sheet 174873



Part No: D2857-2

Job Qty: 20 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/10/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D 06.03.30

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/9/18	0.00	0.00	Start Up Machining-1		SBZ 18/03/31
100	Bandsaw	20 pcs		4/9/18	0.00	3.47	Bandsaw1		SBZ 18/03/31
110	CNC Vertical Machining	20 pcs		4/9/18	0.18	9.62	HAAS1-2		SBZ 18/03/31
130	QC	20 pcs		4/9/18	0.00	0.00	QC8 Machining-1		SK 18/04/02
140	HandFinish	20 pcs		4/9/18	0.00	0.39	HandFinish1		SA 18-04-02
150	QC	20 pcs		4/9/18	0.00	0.00	QC3		BL 18-4-2
160	Powdercoat	20 pcs		4/10/18	0.00	0.27	Powdercoat1		BL 18-4-2
170	QC	20 pcs		4/10/18	0.00	0.00	QC3		11 APR 03 2018
180	Packaging	20 pcs		4/10/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	20 Ea		4/10/18	0.00	0.00	QC21		APR 03 2018

Part Op 100 - Cut blanks 4.425"
Descriptions: 110 - 1-Machine per folio FA840 FOLIO REV:
160 - START TIME: 1.35 00.17.300 FINISH 2.05. 11/3 8700.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	7.4000 ft (.37 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X01.250	7	28	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval		

Description Work Order Deviation

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 832-8200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/31/18



Container No: S057092



Part: D2857-2
 Job No: 174873
 Serial No/Batch: S057092
 Revision:
 Inspector:

Root Cause				
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Inspection incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
Design ☐	Operator ☐	Bending ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐		
Material ☐	Use for Testing ☐	Cuffs ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐		
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐			
OTHER : _____				
		Out of Sequence ☐		Part Moved ☐
		Off-set ☐		Drawing ☐
		Mislabeled ☐		Finish ☐
		Fit/Function ☐	Misread ☐	
		Misaligned/off center ☐	Turning Sequence ☐	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches $\pm$ 0.010	4.310 4.290	4,300	
2	Hinge Bracket	4.000inches $\pm$ 0.010	4.010 3.990	4,000	
3	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,340	
4	Hinge Bracket	1.110inches $\pm$ 0.005	1.115 1.105	1,110	
5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780	1,790	
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1,320	
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	2,000	
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,340	
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	,448	
10	Hinge Bracket	0.171inches $\pm$ 0.005 - 0.000	0.176 0.171	,171	
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	,147	
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	,376	
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	,126	
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	,063	
15	Hinge Bracket	0.166inches $\pm$ 0.005 - 0.000	0.171 0.166	,166	
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	,912	
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	,600	
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	,125	
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	,150	

Plex 3/22/18 12:52 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	